



Dart Aerospace Ltd.
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D5469-1**Job Sheet 198589****Part No:** D5469-1**Job Qty:** 8 pcs**Part Name:** Saddle, Aft, In**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/31/19**Job Tracking No:****Due Date:** 9/9/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** IPP Rev.A 17.07.12 New issue DP Verify DD. IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	8 pcs	9/9/19		0.00	0.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBC 19/11/01
							HAAS - 4		
100	HAAS 4 Axis - B4B	8 pcs	9/9/19		3.00	15.85	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBC 19/11/05
							HAAS - 4 - B4B		
120	QC 2	8 pcs	9/9/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S229056**Part:** D5469-1**Job No:** 198589**Serial No/Batch:** S229056**Revision:** A**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 11/01/19

SBL 19/11/08

				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	8 pcs	9/9/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Handfinish - 1-1 Chemical-B4B	8 pcs	9/9/19	0.00 1.13	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 -	

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				B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Spray Paint - 2 - B4B	8 pcs	9/9/19	0.00 0.20	Spray Paint - 1 - B4B
				Spray Paint - 2 - B4B	RD 19-11-11
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
160	QC 14	8 pcs	9/9/19	0.00 0.00	QC 14 - 15
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	DAS 81
				QC 14 - 24	9-89
				QC 14 - 61	
				QC 14 - 81	
170	Packaging 3-1 - Stock - B4B	8 pcs	9/9/19	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	8	9/9/19	0.00	0.00	QC 21 - SA - 21	
	pcs				QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No. <u>5229056</u> Double check by: <u>DL</u> 1-Machine Step No 1 per Descriptions: Folio FB548 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB548 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB548 and insp 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: <u>5200209</u> 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: <u>5213125</u> 160 - (QC14- Inspect Spray Paint) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D6101-005	Saddle Billet	8 pcs (1 ea)	90-Machining - Issue SN	4X S146167 4X S204755		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
90-Machining - Issue SN	D6101-005	8	26	0		
Part Specifications						
Specifications could not be found.						

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DART AEROSPACE LTD	Work Order:	198589
Description: Saddle, Aft Inboard	Part Number:	D5469-1
Inspection Dwg: D5469 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5469 Rev. A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.998	7.998		
F	0.490	0.510		0.499	0.494	0.498	0.497		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.500	0.500	0.500		
J	1.174	1.184		1.180	1.180	1.180	1.174		
K	0.558	0.578		0.5675	0.568	0.569	0.568		
L	1.174	1.184		1.180	1.180	1.180	1.174		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.250	0.250	0.250	0.251		
S	0.115	0.135		0.130	0.130	0.130	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.231	3.230	3.230		
V	0.230	0.250		0.242	0.243	0.242	0.241		
W	0.115	0.135		0.134	0.125	0.125	0.123		
X	0.352	0.372		0.368	0.368	0.368	0.366		
Y	0.470	0.530		0.500	0.500	0.500	0.500		
Z	0.615	0.635		0.622	0.622	0.622	0.622		
AA	0.053	0.073		0.060	0.060	0.062	0.063		
AB	0.240	0.260		0.252	0.252	0.250	0.250		
AC	1.500	1.520		1.510	1.510	1.510	1.510		
AD	0.115	0.135		0.135	0.135	0.135	0.135		
AE	0.240	0.280		0.265	0.265	0.265	0.265		
AF	0.240	0.260		0.250	0.252	0.253	0.253		
AG	2.000	2.020		2.000	2.000	2.000	2.000		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	19/11/14 / SBL 19/11/05

Audited by:	<i>[Signature]</i>
Date:	19/11/07

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	198589
Description: Saddle, Aft Inboard	Part Number:	D5469-1
Inspection Dwg: D5469 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5469 Rev. A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#5	#6	#7	#8		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.999	7.998	7.998		
F	0.490	0.510		.498	.497	.498	.498		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.499	.501	.500	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.569	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.132	.135	.135		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.128	.128	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.241	.241	.242	.242		
W	0.115	0.135		.122	.122	.122	.121		
X	0.352	0.372		.366	.366	.366	.366		
Y	0.470	0.530		.500	.500	.500	.500		
Z	0.615	0.635		.622	.622	.621	.622		
AA	0.053	0.073		.063	.061	.060	.063		
AB	0.240	0.260		.251	.250	.250	.250		
AC	1.500	1.520		1.510	1.510	1.510	1.510		
AD	0.115	0.135		.125	.135	.135	.135		
AE	0.240	0.280		.265	.265	.265	.265		
AF	0.240	0.260		.253	.253	.252	.252		
AG	2.000	2.020		2.000	2.000	2.000	2.000		
Accept/Reject									

Measured by: SBL
Date: 19/11/06

Audited by: [Signature]
Date: 19/11/07

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG [Signature]	[Signature]

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